

E71T-11



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低碳钢用自保护药芯焊丝
Self-shielded Flux-Cored Wire for Carbon
[Carbon Steel Gasless welding wire]

执行标准 CLASSIFICATION

符合 GB/T 10045 T49ZT1-11NA AWS A5.36 E71T1-11 ISO 17632A T 42 Z Z NO 1

产品特性 DESCRIPTION

SWE71T-11 为细直径自保护药芯焊丝，采用直流正接。电弧柔和稳定，飞溅小，成型美观，脱渣性好，烟尘量小，操作方便，具有良好的焊接操作工艺。

SWE71T-11 is a small diameter self-protected flux-cored welding wire, which adopts DC positive connection. Soft and stable arc, small splash, beautiful shape, great slag removal, low in smoke and dust, and the operation is convenient, has a good welding performance.

应用 APPLICATIONS

用于多种碳钢母材（主要是薄板和镀锌板）全位置自动焊接，适用于家庭式便捷操作。

It is used for all-position automatic welding of various carbon steel base materials (mainly thin plates and galvanized plates) and is suitable for family-style convenient operation.

电源类型 CURRENT TYPE

焊枪接负电极 DC-

过程保护 PROCESS

无需气体保护 Self-shielded Welding

焊接位置 WELDING POSITIONS

平焊、角焊、仰焊、立向上焊、立向下焊 Flat, fillet, tilt, vertical up, vertical down

熔敷金属化学成分 CHEMICAL COMPOSITION OF WELDED METAL %

项目	C	Si	Mn	Al	P	S
GB/T Standard	≤0.30	≤0.90	≤2.00	≤2.00	≤0.03	≤0.03
例值 Typical values	0.22	0.23	0.62	1.42	0.008	0.008

熔敷金属力学性能 MECHANICAL PROPERTIES OF WELDED METAL

试验项目	Rel/Rp0.2 屈服强度 (MPa)	Rm 抗拉强度 (MPa)	A 伸长率 (%)	试验温度 (°C)	KV2(J)
GB/T Standard	≥390	490-670	≥18	-20	27
例值 Typical values	450	620	23		58

作业条件 OPERATING CONDITIONS

直径 Diameter [mm]		Φ0.8	Φ1.0	Φ1.2	Φ1.6
电流 Current [A]	平焊 Flat	80-190	80-200	120-220	180-280
	上立焊/仰焊 V-Up&Overhead	80-170	80-180	120-220	180-260
	下立焊 Vertical Downward	100-190	100-190	130-220	130-220

包装 PACKAGING

1kg 5kg 15kg 盘装 Coil 也可以定制其他包装和规格 Other packaging and other diameters: please consult us